

IN THE CLAIMS:

Please amend Claims 4 and 5 and add Claim 20, as follows:

Claims 1 through 3 (Cancelled)

4. (Currently Amended) A manufacturing method for a toner container provided with a opening, said method comprising:

a fixing step of fixing a position of the toner container and substantially preventing movement of the toner container;

a filling step of filling toner into the toner container, at a position of which is fixed by said fixing step, through the opening, wherein the toner has a true specific gravity which is not more than 2[[,]] and has a particle size which is not more than 20 microns;

a closing step of setting a cover member and closing the opening with the cover member[[,]] after said filling step;

a pressing step of pressing the cover member to the toner container by a pressing mechanism after the cover member is set in the toner container in said closing step; and

a sealing step of gradually welding the cover member and the toner container with each other by a ultrasonic vibration welding member which is in contact with a part of a portion to be welded while changing the contact portion around the opening;

wherein when the welding is carried out in said sealing step, a temperature of the portion being welded is higher than a softening point temperature of the toner.

wherein in said sealing step, the pressing mechanism presses the cover member at upstream and downstream portions, with respect to a moving direction of the welding member, of the portion [[to be]] being welded outside the part where the welding member is in contact with the part of the portion [[to be]] being welded.

5. (Currently Amended) A manufacturing method for a toner container provided with an opening, said method comprising:

a filling step of filling the toner container with toner through the opening, wherein the toner has a true specific gravity which is not more than 2[[.]] and has a particle size which is not more than 20 microns;

a closing step of setting a cover member and closing the opening with the cover member[[.]] after said filling step;

a pressing step of pressing the cover member to the toner container by a pressing mechanism after the cover member is set in the toner container in said closing step; and

a sealing step of gradually welding the cover member and the toner container to each other by an ultrasonic vibration welding member which is in contact with a part of a portion to be welded while changing the contact portion around the opening,

wherein when the welding is carried out in said sealing step, a temperature of the portion being welded is higher than a softening point temperature of the toner.

wherein in said pressing step, the pressing mechanism uses a plurality of pressing members, wherein the plurality of pressing members are movable independently from each other between a pressing position for pressing the cover member and a retracted position

where they do not press the cover member, wherein a pressing member of the plurality of pressing members corresponds to the portion where the welding member is in contact with the cover member is not pressed, and the other pressing members press the cover member.

Claim 6. (Cancelled)

7. (Previously Presented) A method according to Claim 4, wherein in said sealing step, the welding member is circulated around the opening to return to a start point of welding.

8. (Previously Presented) A method according to Claim 4, wherein the welding member has a projected free end.

9. (Previously Presented) A method according to Claim 4, wherein the opening functions to permit removal of a mold during injection molding of the toner container.

Claims 10 through 19 (Cancelled)

20. (New) A method according to Claim 4 or 5, wherein when the welding is carried out in said sealing step, an amplitude of vibration in the welded portion is 15 - 24 μm .